

Work Order ID 57842

Friday, April 16, 2010 1:07:47 PM



Page 1

Item ID: D3911-041

Accept



Setup Start



Revision ID:

Item Name: Basket Installation Stud Assembly, Lower

Stop



Start Date: 4/20/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/28/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 10-4-16 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100

Pick Kit

0.00

Packaging

Packaging

Memo

0.00

110

Small Fab

Small Fab

Memo

0.00

1- Assemble D3911-5 to D3911-1 and install rivet as per dwg
Trim rivet to 1.250" Full Length

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sw04127

Memo

0.00

EJ 10/04/20 6
EJ 10/04/20 6
10 → on page 4

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 501

0.00

10-4-26

sf



140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/27 J

MF

10-4-26

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Picklist Print

Friday, April 16, 2010 1:07:47 PM

Page 1

Work Order ID: 57842



Parent Item: D3911-041



Parent Item Name: Basket Installation Stud Assembly, Lower

Start Date: 4/20/2010

Required Date: 4/28/2010

Comments: IPP RevA: New issue DD verified by:EC

IPP REV:B

Start Qty: 6.00

Required Qty: 6.00

AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP Rev:C as per dwg
revC 10.04.07 Verified by:JLM

Component Item ID/	Replacement	Mfg/ Manufactured	Bin	Primary No	Last	Route 100	Unit of Each	Qty on 2.0000	Remaining 6.0000	Qty	Date EP 10/04/20	Status
D3911-1												

Basket Installation Stud, Lower



Warehouse

Location

Main Warehouse

ST095

Loc Qty

Loc Code

56954

2

56954

2

D3911-5

Manufactured

No

Basket Stud Plate



Warehouse

Location

Main Warehouse

ST095

Loc Qty

Loc Code

57119

21

57375

8

57375

13

MS20615-4M20

Purchased

No

RIVET



Warehouse

Location

Main Warehouse

ST323

Loc Qty

Loc Code

113254

292

114304

16

114324

22

114349

54

200

18

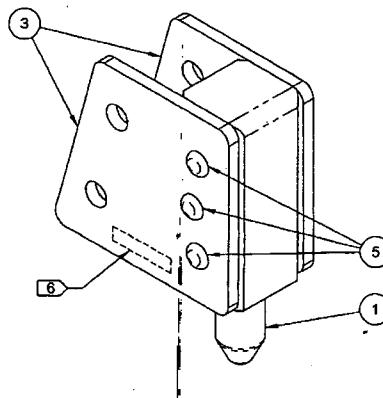
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

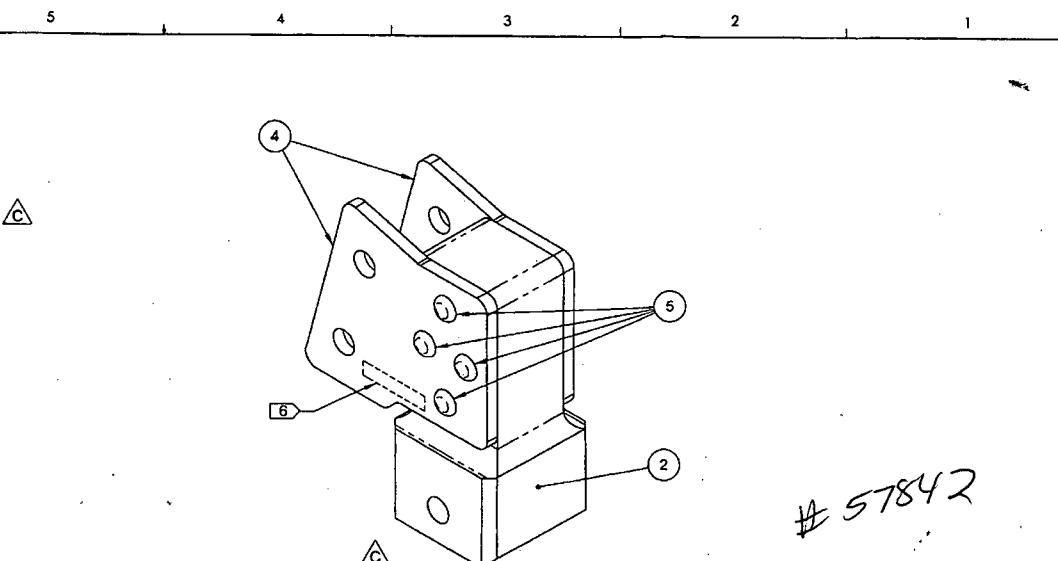
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
	X		D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2	1		D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4	2		D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-04-11
JPH

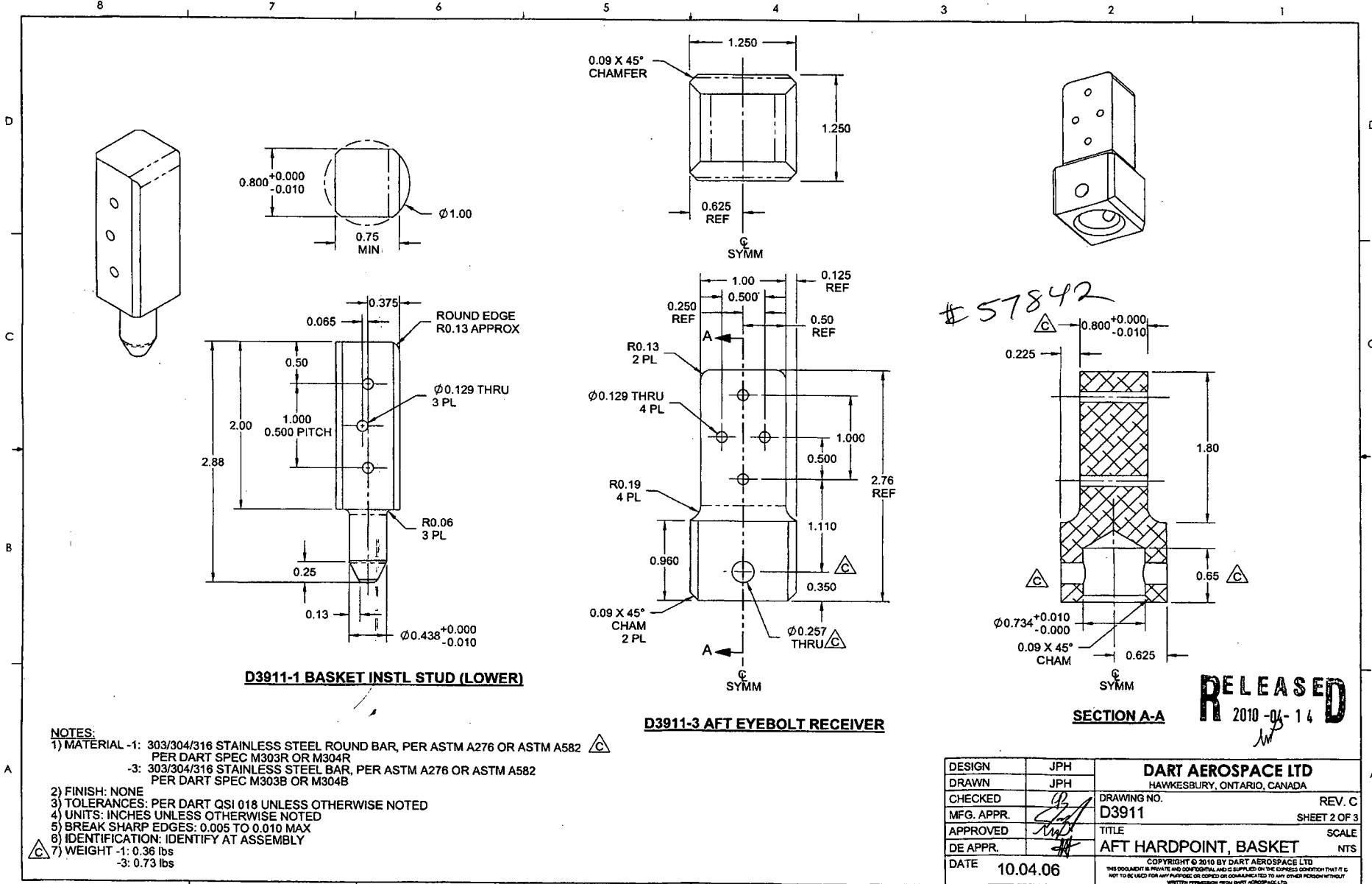
C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-2).		JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			
DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	JPH	DRAWING NO. D3911		
MFG. APPR.	JPH	REV. C		
APPROVED	JPH	TITLE		
DE APPR.	JPH	SCALE		
DATE	10.04.06	NTS		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3911-041 PAR #: N/A Fault Category: Sm. Fnt NCR: Yes No DQA: lh Date: 10.04.27
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: _____ Date: _____

NCR: <u>57842</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/22</u>	<u>110</u>	change 3 rivets because piece was loose. <u>R-C process</u>	<u>lh</u> <u>02142</u>	put new bottom who sit the rivet	<u>lh</u> <u>10/04/22</u>	<u>lh</u> <u>10.04.22</u>	<u>lh</u> <u>02142</u>	<u>lh</u> <u>10.04.22</u>

NOTE: Date & initial all entries



DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CB</i>	DRAWING NO. D3911
MFG. APPR.		REV. C
APPROVED	<i>MHC</i>	SHEET 2 OF 3
DE APPR.	<i>SH</i>	TITLE AFT HARDPOINT, BASKET
DATE	10.04.06	SCALE NTS

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RELEASED
R 2010-01-14
M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

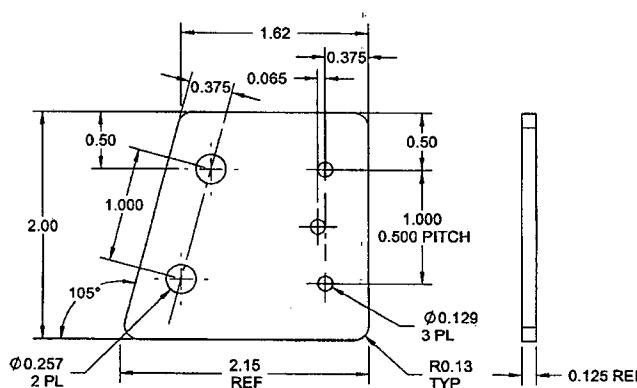
C

B

B

A

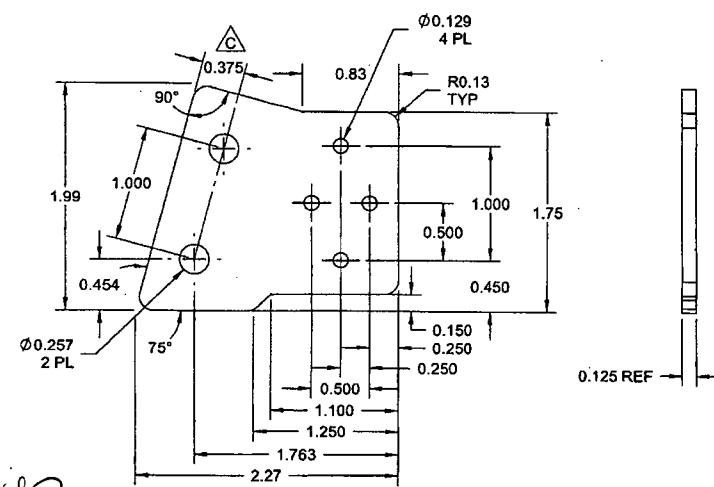
A



D3911-5 BASKET STUD PLATE

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-04-14
JP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JPH</i>	DRAWING NO. D3911	
MFG. APPR.	<i>JPH</i>	REV. C SHEET 3 OF 3	
APPROVED	<i>JPH</i>	TITLE AFT HARDPOINT, BASKET	
DE APPR.	<i>JPH</i>	SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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